



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBT200078
Job Sheet 186773



Part No: RBT200078

Job Qty: 1 Ea

DAS

Part Name: Trunnion Bearing Removal & Install Work Aid

21

9-21



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/18

Job Tracking No:

Due Date: 12/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT200078 Rev. 2A IPP Rev. A 18.07.10 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/3/18	12/3/18	0.00	0.00	Start Up Small Fab-4		MCL
100	Small Fab	1 pcs	12/3/18	12/3/18	0.00	0.07	Small Fab-9		MCL DAS
110	QC	1 pcs	12/3/18	12/3/18	0.00	0.00	QC5		30
130	Packaging	1 pcs	12/3/18	12/3/18	0.00	0.00	Packaging3-2		MCL 9-29
140	QC21-FG	1 Ea	12/3/18	12/3/18	0.00	0.00	QC21		

Part Op 100 - Assemble as per DWG.
Descriptions: 130 - Bag and tag

DAS

21

9-29

DEC 10 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT200078-1	Trunnion Bolt (Hex Head Cap Screw)	1 Ea (1 ea)	90-Start up Operation	5095359
RBT200078-2	Trunnion Body	1 Ea (1 ea)	90-Start up Operation	5105226
RBT200078-3	Trunnion Spreader	1 Ea (1 ea)	90-Start up Operation	5105250

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBT200078-1	1	1	0
	RBT200078-2	1	3	0
	RBT200078-3	1	3	0

Part Specifications



Container No: S136404



Part: RBT200078

Job No: 186773

Serial No/Batch: S136404

Revision: 2A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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www.dartaerospace.com

Plex 11/21/18 10:22 AM Dart.lajeunesse.marie

Date: 12/10/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

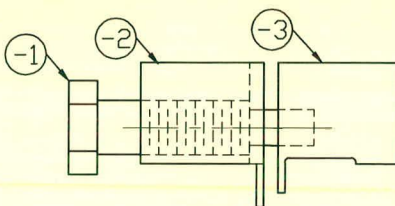
QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐			
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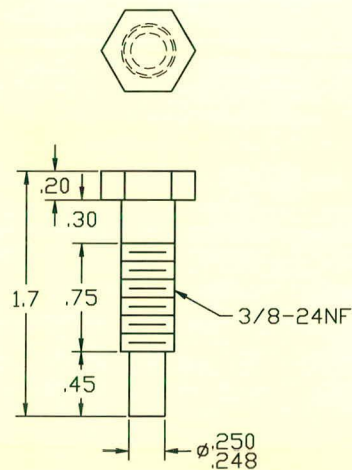
Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause		FAULT CATEGORY	
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐



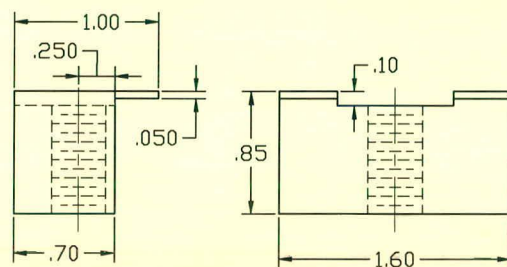
ASSEMBLY VIEW



(1)
BOLT

3/16 TEXT "RBT200078"

DRILL & TAP
3/8-24NF THRU



(2)
BODY
HEAT TREAT 35-40 Rc

SHOP COPY

RETURN TO
ENGINEERING

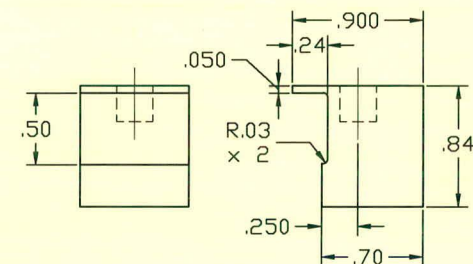
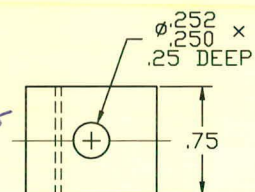
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 186773 M5
1871-21



(3)

SPREADER
HEAT TREAT 35-40 Rc

ASSY QTY	QTY	B/D	PART #	UNIT QTY	DESCRIPTION	MAT.	B/D INFORMATION OR SPECIFICATIONS
		W/D	-1	1	HEX HEAD CAP SCREW	BLACK	3/8-24 x 1-3/4
			-2	1	BODY	4140	1 x 1-1/4 x 1-3/4
			-3	1	SPREADER	4140	1 x 1-1/4 x 7/8
ASSY							

REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	CHANGED BOLT PIN FROM #247, AND -3 HOLE FROM #250; ALSO CHANGED P/N FROM T200078	8/16/06	WP -
2	ADDED NEW TITLE BLOCK, BOM, & REVISIONS TABLE, AND ASSEMBLY VIEW. ALSO CHANGED MATERIAL DISCRPTION FROM 1 in. WIDE.	3/6/08	WP RW
2A	CH'D BOM LENGTH FROM 13/16 TO 7/8 -3 PER R.W.	12/17/10	RJC RW

RED BARN MACHINE

TITLE TRUNNION BEARING REMOVAL
AND INSTALLATION WORK AID

DWG NO. RBT200078

REV 2A

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: COLE	
TOLERANCES ON:		APPROVED: D. Ward	
DECIMALS		HEAT TREAT LISTED BY PART	
XXX ± .005		FINISH BLACK OXIDE	
XX ± .01		USED ON MODEL	
X ± .1		BELL 204, 205,	
UNLESS OTHERWISE SPECIFIED		206, 212	
1. BREAK ALL SHARP EDGES		SCALE NTS	
.015 x 45° PR .015 R		DATE 10-15-01	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SHEET 1 of 1	

